



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2432-3

Job Sheet 179959



Part No: D2432-3

Job Qty: 8 ea

Part Name: 206 (24") Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/27/18

Job Tracking No:

Due Date: 7/11/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV H IPP REV:A AS PER REV G 12-07-24 JLM VERIFIED BY:DD IPP REV:B 12.10.17 AS PER DWG REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	7/11/18	7/11/18	0.00	0.00	Start Up Container		21 18/06/20
120	Waterjet	8 pcs	7/11/18	7/11/18	0.00	1.91	Waterjet 2 OMAX		21 18/06/20
130	CNC Vertical Machining	8 pcs	7/11/18	7/11/18	0.66	13.14	HAAS 1		DJP 18-08-16
140	QC	8 pcs	7/11/18	7/11/18	0.00	0.00	QC2		DJP 18-08-16
150	QC	8 pcs	7/11/18	7/11/18	0.00	0.00	QC8		DJP 18-08-16
160	Packaging	8 pcs	7/11/18	7/11/18	0.00	0.00	Packaging3	51-146	21 18/06/20
170	QC21-SA	8 Ea	7/11/18	7/11/18	0.00	0.00	QC21		21 18/06/20

Part Op 120 - Cut Blank as per D2432 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio B122 and Dwg D2432 Identify as D2432-3

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	29.6000 sf (3.7 ea)	90-Start up Operation	5045596

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	30	1,319	0

Part Specifications

Specifications could not be found.

Plex 6/27/18 8:38 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																					
Description Work Order Deviation			Disposition																																																						
DART AEROSPACE Container No: S089210 Part: D2432-3 Job No: 179959 Serial No/Batch: S089210 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/05/18			Completed By																																																						
			Lead hand / Supervisor Approval Verification																																																						
			QC / QA Coordinator Approval																																																						
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OTHER : _____																																																									

DART AEROSPACE LTD		Work Order: 179959
Description: 206 Bearpaw		Part Number: D2432-3
Inspection Dwg: D2432	Rev: H	Page 1 of 1

INSPECTION SHEET

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.006/-0.001	.260 ✓		G.P.	
B	0.93	+/-0.030	.932 ✓		Uer	
C	0.300	+0.030/-0.000	.310 ✓		D.G.	
D	0.06 x 45°	+/-0.030 x +/-0.5°	.06 x 45° ✓		Uer	
E	2.000	+/-0.010	2.000 ✓		Uer	
F	11.000	+/-0.010	11.000 ✓		TAPE	
G	20.000	+/-0.010	20.000 ✓		TAPE	
H	4.250	+/-0.005	4.250 ✓		Uer	Calculated
I	5.50	+/-0.030	5.500 ✓		Uer	Calculated
J	19.00	+/-0.030	19.000 ✓		TAPE	Calculated
K	23.75	+/-0.030	23.75 ✓		TAPE	
L	0.25 x 45°	+/-0.030 x +/-0.5°	.25 x 45° ✓		TAPE	
M	0.95	+/-0.030	0.962 ✓		Uer	
N	0.63	+/-0.030	0.640 ✓		Uer	
O	0.250	+/-0.010	0.255 ✓		Uer	
P	0.380	+0.030/-0.010	0.400 ✓		Uer	
Q	1.4	+/-0.030	1.410 ✓		Uer	Calculated
R	0.38	+/-0.030	0.38 ✓		Uer	
S	R0.25	+/-0.030	R0.25 ✓		R.G.	
T						
U						
V						
W						
X						
Y						
Z						
AA						
AB						

Measured by: 52 9-89	Checked by: mark	QC Inspector:
Date: 18/08/15	Date: 18/08/16	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	16.06.23	New Issue	KJ	

DQA: _____ Date: _____

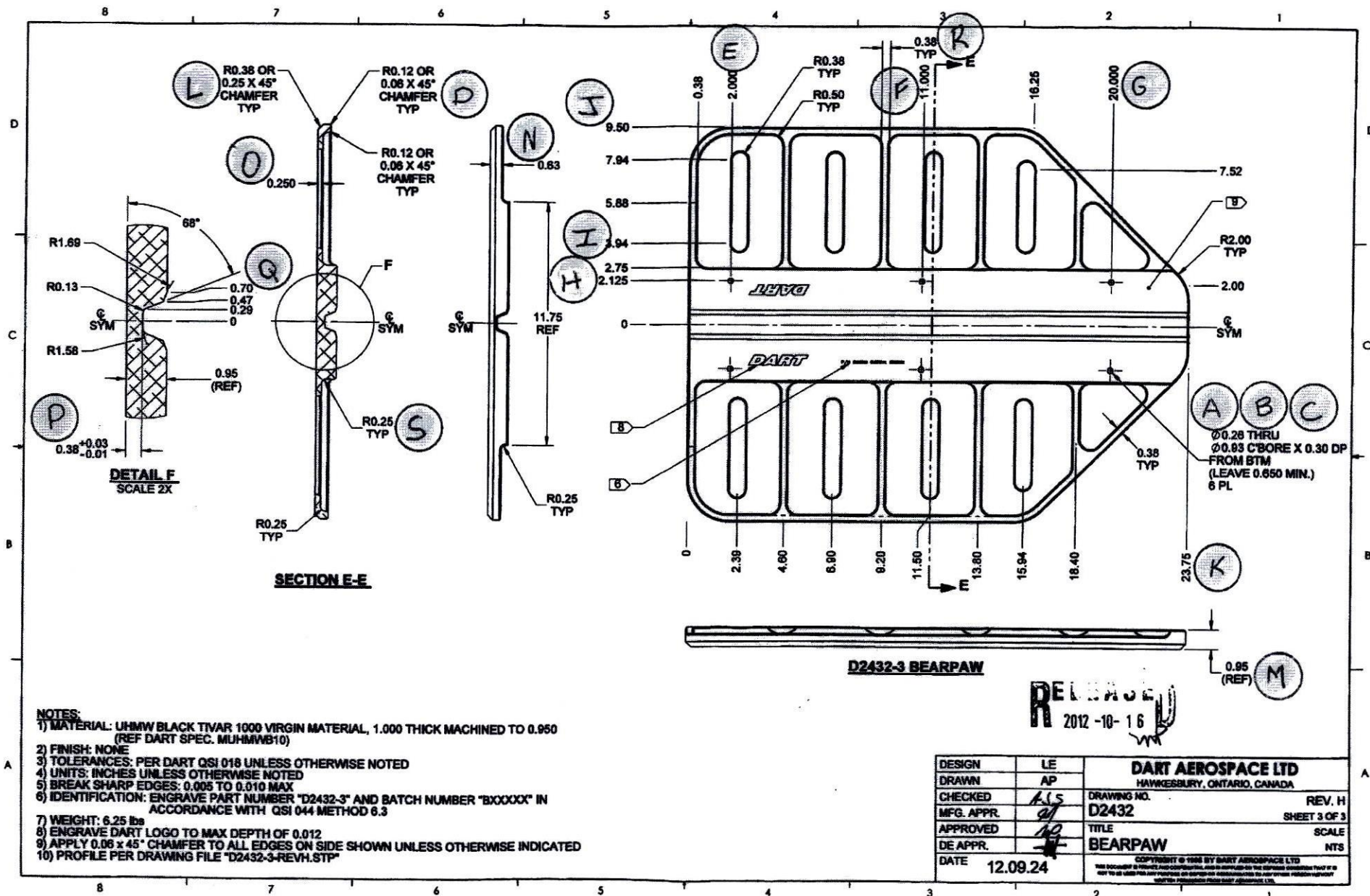


WORK ORDER NON-CONFORMANCE / UPDATE

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
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